




# Work Order ID 62483

Thursday, September 30, 2010 2:22:18 PM


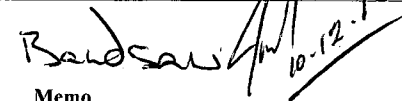
Page 1


Item ID:	D3278-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Support				Stop	
Start Date:	9/30/2010	Start Qty:	40.00		Cust Item ID:	
Required Date:	10/8/2010	Req'd Qty:	40.00		Customer:	
Reference:						


Approvals:	Process Plan:		Date:	10-9-30	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3278	Rev C								

100		SHEAR		10-12-16	0.00				
	Shear		Memo		0.00				
	Shear		Cut blank: 2.00" x 1.00" x 2.550" long						

110		HAAS CNC VERTICAL MACHINING #1			0.00				
	HAAS 1		Memo		0.00				
	HAAS CNC vertical machine #1		1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and Tumble Identify as D3278-2						

120		QC2- Inspect parts off machine FAI/FAIB			0.00				
	QC		Memo		0.00				
	Quality Control								

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries




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Page 2

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Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>ml 10/12/21</i>		<u>40</u>	<u>0</u>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		<i>ml 10/12/22</i>		<u>40</u>	<u>0</u>		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>ml 15951</i> Memo START TIME: <i>8:05</i> <i>3:20</i> FINISH TIME: <i>8:35</i>	0.00  0.00				<u>110</u>	<u>16</u>	<u>10-12-23</u>	

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Page 3

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Required Date:	10/8/2010	Req'd Qty: 40.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00		=) JM 10/12/23		40	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>Sylve</u>  Memo	0.00  0.00							10/30/2010 (400) SP
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							GK 11/01/03 C211101/03

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# Picklist Print

Thursday, September 30, 2010 2:22:22 PM

Page 1

Work Order ID: 62483



Parent Item: D3278-2



Parent Item Name: Support

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B1.000X02.00  
0

Purchased

No

100

f

25.8220

0.2337

9.84



6061-T6 Bar 1.00 x 2.00



SA 10/12/16

i 2R + 6Rt

Location

Loc Qty

Loc Code

MAT

23.592

112567

0

~ 115045

23.592

MAT03

2.23

112567

2.23

9.5 Rt

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 62483
<b>Description:</b> Support		<b>Part Number:</b> D3278-2
<b>Inspection Dwg:</b> D3278	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.098	✓		Verif SL-3	
0.359	+/-0.005	.359	✓		~	
0.609	+/-0.010	.611	✓		~	
0.250	+/-0.010	.250	✓		~	
1.480	+/-0.005	1.480	✓		~	
R0.125	+/-0.010	.125	✓		R-G	
0.119	+0.005/-0.004	.120	✓		~	
2.439	+/-0.010	2.440	✓		~	
1.980	+/-0.010	1.981	✓		~	
R0.13	+/-0.030	.130	✓		~	
Ø0.257	+0.005/-0.000	.258	✓		~	
R0.375	+/-0.010	.375	✓		~	
0.875	+/-0.010	.875	✓		~	
0.500	+/-0.010	.500	✓		~	
R0.400	+/-0.010	.400	✓		~	
R1.00	+/-0.030	1.00	✓			
1.720	+/-0.010	1.721	✓		~	
R0.125	+/-0.010	.125	✓		~	
0.125	+/-0.010	.128	✓		~	

<b>Measured by:</b> SL	<b>Audited by:</b> gml	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/12/20	<b>Date:</b> 10/12/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	AF BE

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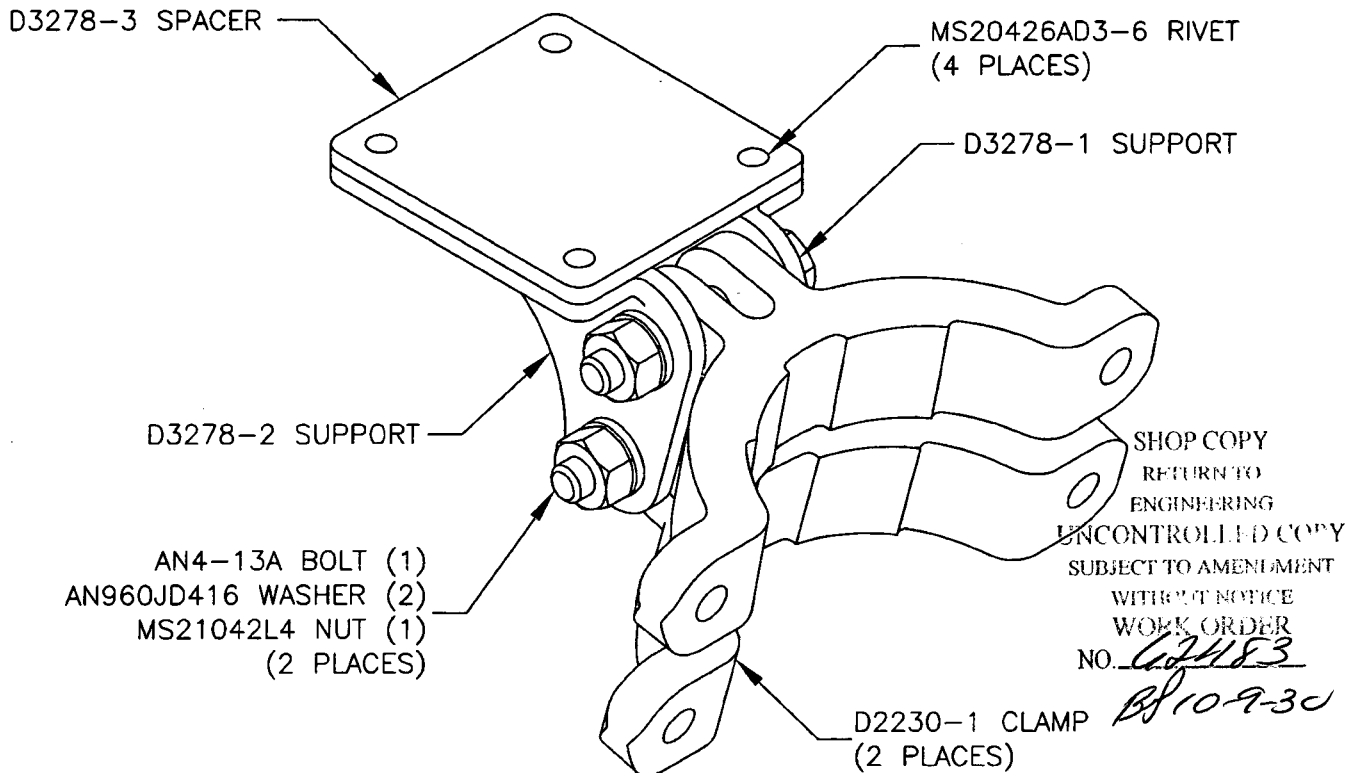
**NOTE:** Date & initial all entries

**DART**

DESIGN 49	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07-08-08

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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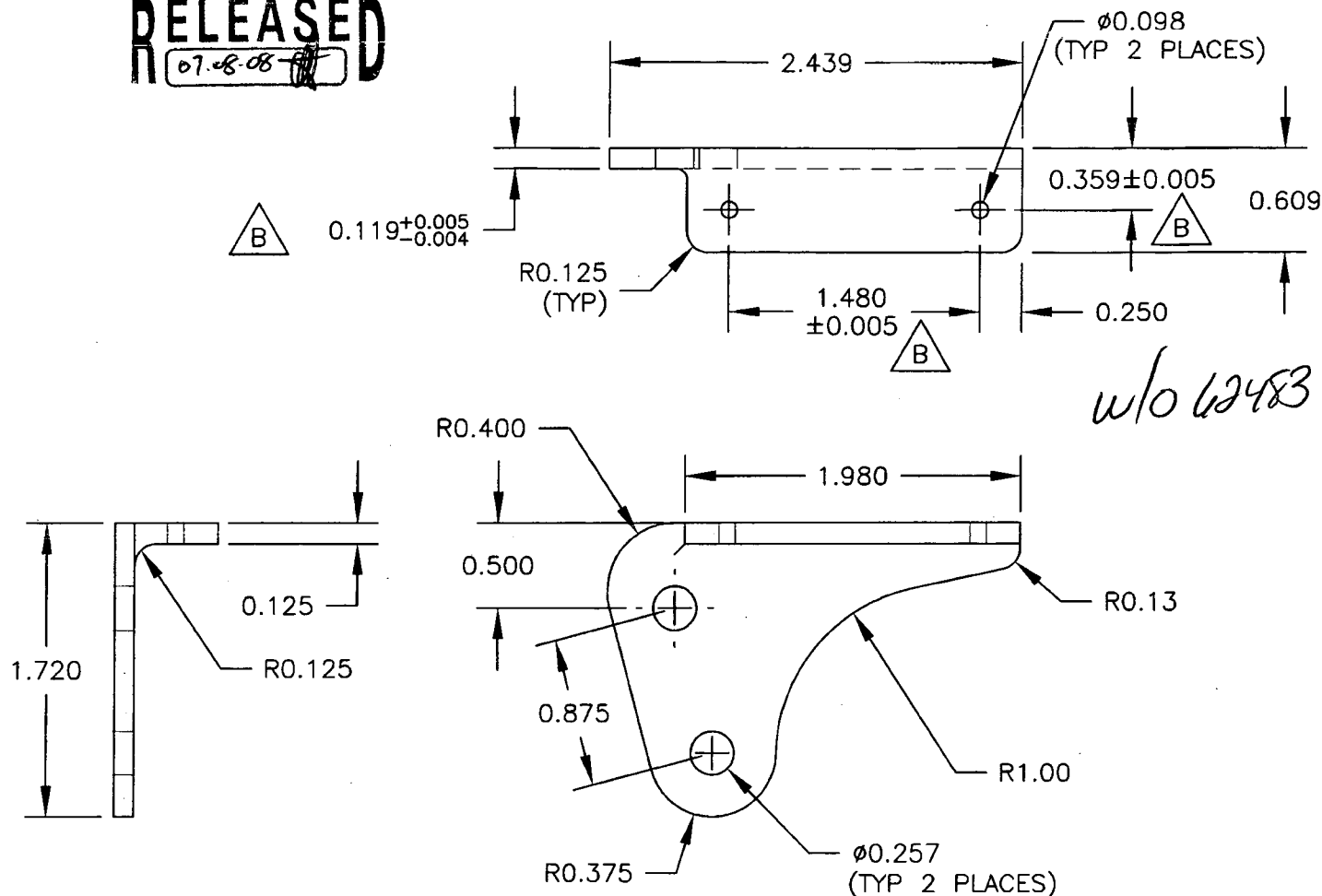
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**DART**

DESIGN <i>qp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRF"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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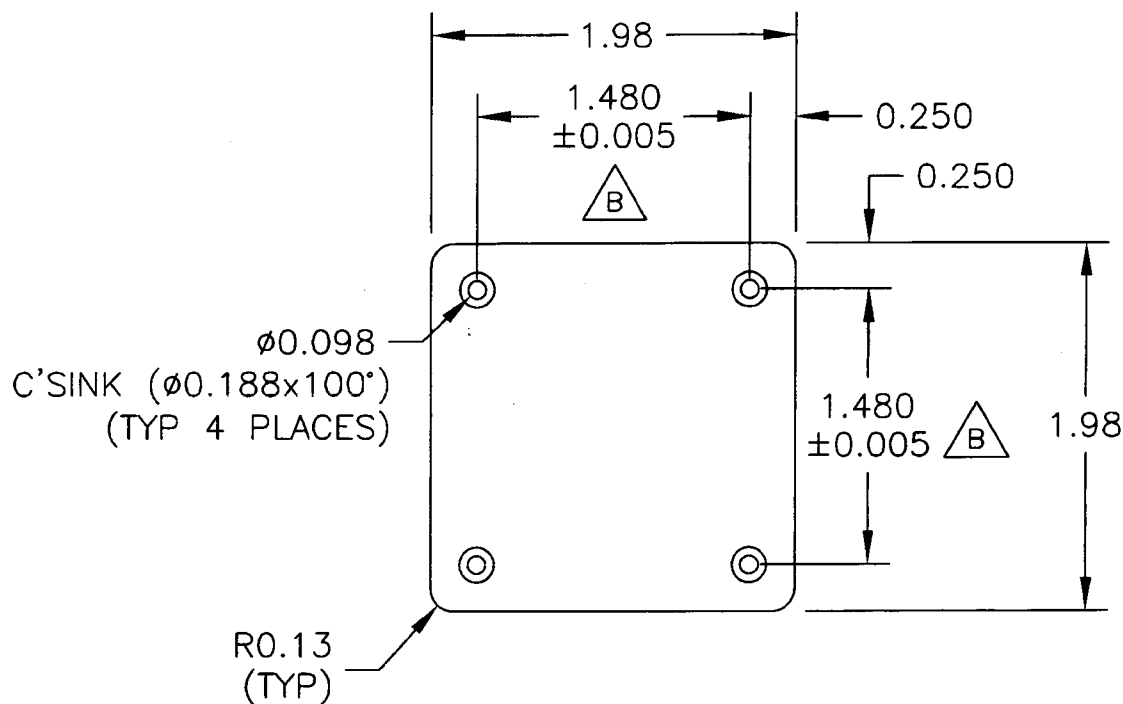
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DESIGN <i>97</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED  
07.08.08

*W/O 62483*



### D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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